

LIGHTWEIGHT MEMBER FOR REINFORCING, SEALING OR BAFFLING

CLAIM OF BENEFIT OF FILING DATE

The present application claims the benefit of the filing date of U.S. Provisional
5 Application Serial No. 60/423,771, filed November 5, 2002, hereby incorporated by
reference.

TECHNICAL FIELD

The present invention relates to a lightweight member, which is employed for
10 providing reinforcing, sealing, baffling, combinations thereof or the like to a structure of
an article of manufacture such as an automotive vehicle.

BACKGROUND

For many years, industries such as the transportation industry have been
15 innovatively designing members for enhancing structural reinforcement, damping,
sealing, baffling, thermal insulation and acoustic absorption characteristics of articles
such as furniture, buildings and transportation vehicles (e.g., automotive vehicles,
boats, trains, busses, airplanes or the like). Design of such members can involve
several different considerations, and these considerations may need to be balanced
20 against one another to achieve a desired result. Examples of such considerations
include, without limitation, strength, weight, and cost of the members. Other
considerations include compatibility of the members with articles of manufacture, ease
of assembling the members to articles of manufacture, ability of the members to provide
desired levels of damping, reinforcement or sealing or other like considerations.

25 In the interest of continuing such innovation, the present invention provides an
improved member suitable for providing baffling, sealing, reinforcing, a combination
thereof or the like to a structure of an article of manufacture.

BRIEF DESCRIPTION OF THE DRAWINGS

30 Fig. 1 illustrates an exemplary reinforcement member formed in accordance with
an aspect of the present invention.

Fig. 2 illustrates an exemplary graph of experimental testing data for carrier members formed in accordance with an aspect of the present invention.

Fig. 3 illustrates an exemplary application of the reinforcement member of Fig. 1 to a component of an automotive vehicle in accordance with an aspect of the present invention.

Fig. 4 illustrates another exemplary member formed in accordance with the present invention.

Fig. 5 illustrates a structure having a cavity suitable for receiving the member of Fig. 4.

DETAILED DESCRIPTION OF THE INVENTION

The present invention is predicated upon an improved process for forming reinforcement members, and articles incorporating the same. Although it is contemplated that the reinforcement member may be employed in a variety of articles of manufacture, for exemplary purposes, the reinforcement member is discussed herein as being employed in an automotive vehicle. The process for forming the reinforcement member and for applying the reinforcement to an automotive vehicle preferably includes one or a combination of the following steps:

- i) providing a polymeric material such as a polyamide;
- ii) molding the polymeric material to form a carrier member with a cellular (e.g., a microcellular) structure;
- iii) applying an expandable material to a surface of the carrier member for forming the reinforcement member;
- iv) placing the reinforcement member within a cavity of an automotive vehicle, the cavity being defined by one or more walls of a structure of the automotive vehicle; and
- v) activating the expandable material to form a structural foam that is adhered to the carrier member and the one or more walls of the structure of the automotive vehicle.

Polymeric Material for the Carrier Member

The polymeric material for the carrier member may include any polymer such as a plastic, an elastomer, a thermoplastic, a thermosettable polymer, a combination thereof or the like. The polymeric material may also include one or more non-polymeric materials such as additives and fillers. In preferred embodiments, the polymeric material includes up to at least about 30 % or more by weight thermoplastics, more preferably at least about 45 % by weight thermoplastics and even more preferably at least about 60 % by weight thermoplastics.

Exemplary thermoplastic materials suitable for the polymeric material of the carrier member include, without limitation, polypropylenes, ethylene copolymers and terpolymers, polyolefins, polyesters, nylons, polyamides, polysulfones, poly(butylene terephthalates), poly(ethylene terephthalates), polyvinylchlorides, chlorinated polyvinylchlorides, polyvinylidene fluorides, high or low density polyethylenes, ethylene/chlorotrifluoroethylenes, polyethyl-ethyl ketones, combinations thereof or the like. It is contemplated that the polymeric materials may be filled (e.g., with fibers, minerals, clays, carbonates, combinations thereof or the like) or unfilled. According to one highly preferred embodiment, the polymeric material for the carrier member is formed of between about 60% and about 80% by weight polyamide or nylon, and more particularly, nylon 6 or nylon 6,6, which is preferably filled with between about 20% to about 40% by weight glass fibers or minerals. One exemplary nylon is sold under the tradename NYLENE (e.g., NYLENE 5133) and is commercially available from Custom Resins, P.O. Box 46, Henderson, Kentucky, 42420. Other nylons include mineral filled NYLENE 6140 and impact modified NYLENE 4114.

Molding the Polymeric Material into the Carrier Member

It is contemplated that the carrier member may be formed, shaped or both according to a variety of techniques such as extrusion or the like. It is preferable, however, for the carrier member to be formed or shaped via a molding process such as injection molding, blow molding or the like. In a highly preferred embodiment, the carrier member is molded such that it has a cellular structure, which may be internal,

external or both. Examples of molding processes, which provide cellular structures in polymers are disclosed in U.S. Patents numbered 6,379,059; 6,322,347; 6,294,115; 6,284,810; 6,235,380; 6,231,942; 6,169,122 all of which are expressly incorporated by reference for all purposes.

5 According to one preferred embodiment, the polymeric material of the present invention is injected molded, extruded, or otherwise molded according to a process, which preferably forms relatively small open or closed cells of substantially uniform size and shape (e.g., 1-100 microns in diameter) within the carrier member. According to the technique, a blowing agent is substantially completely dissolved in the polymeric
10 material for forming a substantially single-phase substantially homogeneous solution. It is contemplated that chemical blowing agents may be employed such as azodicarbonamide, dinitrosopentamethylenetetramine, 4,4'-oxy-bis-(benzenesulphonylhydrazide), trihydrazinotriazine and N, N'-dimethyl-N,N'-dinitrosoterephthalamide, combinations thereof or the like. In a preferred embodiment,
15 a physical blowing agent (e.g., a generally inert one) is dispersed (e.g., uniformly or selectively) within the polymeric material. Such a blowing is typically a gas and in a highly preferred embodiment the gas is or includes either N₂, CO₂, a combination thereof or the like that is dissolved into the polymeric material at a sufficiently high temperature and at a sufficiently high pressure to maintain the gas in a supercritical
20 state (e.g., as a supercritical fluid). In this manner, the blowing agent may be more uniformly dispersed within the polymeric material and may produce a finer cell structure (e.g., a microcellular structure).

When injection molding is employed, the solution of blowing agent and polymeric material is supplied (e.g., injected) into a mold of an injection molding apparatus. While
25 it is contemplated that the polymeric material may be supplied to the mold prior to mixing the blowing agent and polymeric material to form the solution, it is preferable that the polymeric material and blowing agent be mixed to form the solution within the mold.

To form the carrier member, the temperature, the pressure, the solubility change rate, a combination thereof or the like of polymeric material and blowing agent are
30 changed (e.g., reduced) such that the polymeric material becomes supersaturated with

the blowing agent. In turn, the blowing agent rapidly nucleates within the solution creating the cellular or microcellular structure therein. Preferably, at the same time, the polymeric material of the solution is solidifying to form the carrier member with the cellular structure. Advantageously, the polymeric material, the molding technique or both together can assist in providing improved shaping or moldability of the carrier member.

Structurally, the carrier member may be formed in a variety of shapes and configurations depending upon the mold or technique employed to form the member. Exemplary configurations for carrier members are disclosed in U.S. Patent Application serial number 09/502,686, filed February 11, 2000, titled "Structural Reinforcement System for Automotive Vehicles", which is expressly incorporated herein by reference for all purposes. Further, it should be understood that the carrier member may be formed as part of a baffle, a reinforcement or a seal. Examples of configurations for seals, baffles and reinforcements are disclosed in U.S. Patent Application serial no. 60/482,896, titled Fastenable Member For Sealing, Baffling or Reinforcing and Method of Forming Same, filed June 26, 2003; U.S. Patent Application serial no. 60/504,260, titled System and Method Employing a Porous Container for Sealing, Baffling or Reinforcing, filed September 18, 2003; or U.S. Patent Application serial no. 10/464,251 titled System and Method for Sealing, Baffling or Reinforceing, filed June 18, 2003; all of which are expressly incorporated herein by reference for all purposes.

In a preferred embodiment, carrier member includes one or more ribs for lowering the weight of the carrier member and for improving the strength characteristics of the carrier member. Referring to Fig. 1, there is illustrated one exemplary carrier member 10 formed in accordance with the present invention. The carrier member 10 is shown as elongated and skeletal in nature. Preferably, the carrier member 10 includes a plurality of laterally extending ribs 12 spaced apart along a length (L) of the carrier member 10 and a plurality of longitudinally extending ribs 14 spaced apart along a width (W) of the carrier member 10. As shown, the ribs 12, 14 form a criss-cross pattern for providing strength to the carrier member 10. In the illustrated embodiment, the ribs 12, 14 are substantially shaped as planar panels that are square or rectangular, however, it is contemplated that the ribs 12, 14 may be configured in a variety of shapes.

Advantageously, it has been found that carrier members molded to have cellular characteristics in accordance with the present invention exhibit acoustic, sealing, strength and stiffness characteristics similar to carrier members having substantially identical shapes and configurations, but which are non-cellular or are formed of internally continuous or solid materials. Referring to Fig. 2, a graph is illustrated with five lines 20, 22, 24, 26, 28, which correspond to five carrier members having a substantially identical shape and which include a rib construction such as that of the carrier member 10 of Fig. 1. In Fig. 2, the first line 20 corresponds to an internally solid or non-cellular carrier member. The second line 22, the third line 24, the fourth line 26 and the fifth line 28 correspond to carrier members, which have been formed with cellular structures according to the present invention and which, as a result, have respective reduced weights of 3 %, 5 %, 10 %, 15 % and 20 % compared to the internally solid carrier member. For testing, each of the five carrier members was exposed to a load and, as can be seen, the lighter weight carrier members advantageously performed substantially as well as the heavier carrier members and particularly the internally solid member. Thus, it can be seen that carrier members, and particularly carrier members having rib constructions, can be reduced in weight up to 5 %, 10 %, 15 %, 20 % or more over an internally solid part while still retaining a substantial portion of their strength.

Applying Expandable Material to the Carrier Member to Form a Reinforcement Member

When used in automotive vehicles or other articles of manufacture, it is preferable for an expandable material to be applied to the carrier member of the invention for forming a reinforcement member. In Fig. 1, an expandable material 30 is disposed upon an outer surface 32 of one of the longitudinal ribs 14 of the carrier member 10 for forming a reinforcement member 40. It is contemplated, however, that the expandable material may be placed upon any surface of any carrier member formed in accordance with the present invention.

The expandable material 30 may be formed of several different materials. Generally speaking, the member 40 may utilize technology and processes for the forming and applying the expandable material 30 such as those disclosed in U.S.

Patent Nos. 4,922,596, 4,978,562, 5,124,186, and 5,884,960 and commonly owned, co-pending U.S. Application Serial Nos. 09/502,686 filed February 11, 2000 and 09/524,961 filed March 14, 2000, all of which are expressly incorporated by reference for all purposes. Preferably, the expandable material 30 is formed of a high compressive strength and stiffness heat activated reinforcement material having foamable characteristics. The material may be generally dry to the touch or tacky and can be placed upon the carrier member 10 or the like in any form of desired pattern, placement, or thickness, but is preferably of substantially uniform thickness. One exemplary expandable material is L-5204 structural foam available through L&L Products, Inc. of Romeo, Michigan.

Though other heat-activated materials are possible for the expandable material 30, a preferred heat activated material is an expandable polymer or plastic, and preferably one that is foamable. A particularly preferred material is an epoxy-based structural foam. For example, and without limitation, the structural foam may be an epoxy-based material, including an ethylene copolymer or terpolymer that may possess an alpha-olefin. As a copolymer or terpolymer, the polymer is composed of two or three different monomers, i.e., small molecules with high chemical reactivity that are capable of linking up with similar molecules.

A number of epoxy-based structural reinforcing or sealing foams are known in the art and may also be used to produce the structural foam. A typical structural foam includes a polymeric base material, such as an epoxy resin or ethylene-based polymer which, when compounded with appropriate ingredients (typically a blowing and curing agent), expands and cures in a reliable and predictable manner upon the application of heat or the occurrence of a particular ambient condition. From a chemical standpoint for a thermally-activated material, the structural foam is usually initially processed as a flowable thermoplastic material before curing. It will cross-link upon curing, which makes the material incapable of further flow.

An example of a preferred structural foam formulation is an epoxy-based material that is commercially available from L&L Products of Romeo, Michigan, under the designations L5206, L5207, L5208, L5209. One advantage of the preferred structural foam materials over prior art materials is that the preferred materials can be

processed in several ways. The preferred materials can be processed by injection molding, extrusion compression molding or with a mini-applicator. This enables the formation and creation of part designs that exceed the capability of most prior art materials. In one preferred embodiment, the structural foam (in its uncured state) generally is dry or relatively free of tack to the touch and can easily be attached to the carrier member 10 through fastening means which are well known in the art.

While the preferred materials for fabricating the expandable material 30 have been disclosed, the expandable material can be formed of other materials provided that the material selected is heat-activated or otherwise activated by an ambient condition (e.g. moisture, pressure, time or the like) and cures in a predictable and reliable manner under appropriate conditions for the selected application. One such material is the epoxy based resin disclosed in U.S. Patent No. 6,131,897, the teachings of which are incorporated herein by reference, filed with the United States Patent and Trademark Office on March 8, 1999 by the assignee of this application. Some other possible materials include, but are not limited to, polyolefin materials, copolymers and terpolymers with at least one monomer type an alpha-olefin, phenol/formaldehyde materials, phenoxy materials, and polyurethane materials with high glass transition temperatures. See also, U.S. Patent Nos. 5,766,719; 5,755,486; 5,575,526; and 5,932,680, (incorporated by reference). In general, the desired characteristics of the expandable material 30 include relatively high stiffness, high strength, high glass transition temperature (typically greater than 70 degrees Celsius), and adhesion durability properties. In this manner, the material does not generally interfere with the materials systems employed by automobile manufacturers. Exemplary materials include materials sold under product designation L5207 and L5208, which are commercially available from L & L Products, Romeo, Michigan.

In applications where the expandable material 30 is a heat activated, thermally expanding material, an important consideration involved with the selection and formulation of the material comprising the structural foam is the temperature at which a material reaction or expansion, and possibly curing, will take place. For instance, in most applications, it is undesirable for the material to be reactive at room temperature or otherwise at the ambient temperature in a production line environment. More

typically, the structural foam becomes reactive at higher processing temperatures, such as those encountered in an automobile assembly plant, when the foam is processed along with the automobile components at elevated temperatures or at higher applied energy levels, e.g., during paint curing steps. While temperatures encountered in an automobile assembly operation may be in the range of about 148.89° C to 204.44°C (about 300°F to 400°F), body and paint shop applications are commonly about 93.33°C (about 200°F) or slightly higher. If needed, blowing agent activators can be incorporated into the composition to cause expansion at different temperatures outside the above ranges.

Generally, suitable expandable foams have a range of expansion ranging from approximately 0 to over 1000 percent. The level of expansion of the expandable material 30 may be increased to as high as 1500 percent or more. Typically, strength and stiffness are obtained from products that possess low expansion.

Some other possible materials for the expandable material 30 include, but are not limited to, polyolefin materials, copolymers and terpolymers with at least one monomer type an alpha-olefin, phenol/formaldehyde materials, phenoxy materials, and polyurethane. See also, U.S. Patent Nos. 5,266,133; 5,766,719; 5,755,486; 5,575,526; 5,932,680; and WO 00/27920 (PCT/US 99/24795) (all of which are expressly incorporated by reference). In general, the desired characteristics of the resulting material include relatively low glass transition point, and good adhesion durability properties. In this manner, the material does not generally interfere with the materials systems employed by automobile manufacturers. Moreover, it will withstand the processing conditions typically encountered in the manufacture of a vehicle, such as the e-coat priming, cleaning and degreasing and other coating processes, as well as the painting operations encountered in final vehicle assembly.

In another embodiment, the expandable material 30 is provided in an encapsulated or partially encapsulated form, which may comprise a pellet, which includes an expandable foamable material, encapsulated or partially encapsulated in an adhesive shell. An example of one such system is disclosed in commonly owned, co-pending U.S. Application Serial No. 09/524,298 ("Expandable Pre-Formed Plug"), hereby incorporated by reference.

In addition, as discussed previously, preformed patterns may also be employed such as those made by extruding a sheet (having a flat or contoured surface) and then die cutting it according to a predetermined configuration in accordance with the chosen pillar structure, door beam, carrier member or the like, and applying it to thereto.

5 The skilled artisan will appreciate that the system may be employed in combination with or as a component of a conventional sound blocking baffle, or a vehicle structural reinforcement system, such as is disclosed in commonly owned co-pending U.S. Application Serial Nos. 09/524,961 or 09/502,686 (hereby incorporated by reference).

10 It is contemplated that the material of the expandable material 30 could be delivered and placed into contact with the assembly members, through a variety of delivery systems which include, but are not limited to, a mechanical snap fit assembly, extrusion techniques commonly known in the art as well as a mini-applicator technique as in accordance with the teachings of commonly owned U.S. Patent No. 5,358,397
15 ("Apparatus For Extruding Flowable Materials"), hereby expressly incorporated by reference. In this non-limiting embodiment, the material or medium is at least partially coated with an active polymer having damping characteristics or other heat activated polymer, (e.g., a formable hot melt adhesive based polymer or an expandable structural foam, examples of which include olefinic polymers, vinyl polymers, thermoplastic
20 rubber-containing polymers, epoxies, urethanes or the like) wherein the foamable or expandable material can be snap-fit onto the chosen surface or substrate; placed into beads or pellets for placement along the chosen substrate or member by means of extrusion; placed along the substrate through the use of baffle technology; a die-cast application according to teachings that are well known in the art; pumpable application
25 systems which could include the use of a baffle and bladder system; and sprayable applications.

Installing the Reinforcement Member To an Automotive Vehicle

30 Once completed, the reinforcement member of the present invention is preferably installed to an automotive vehicle although it may be employed for other articles of manufacture such as boats, buildings, furniture, storage containers or the

like. The reinforcement member may be used to reinforce a variety of components of an automotive vehicle including, without limitation, body components (e.g., panels), frame components (e.g., hydroformed tubes), pillar structures (e.g., A, B or C-pillars), bumpers, roofs or the like of the automotive vehicle.

5 In one preferred embodiment, the reinforcement member is placed at least partially within a cavity of a component of an automotive vehicle wherein the cavity is defined by one or more walls or surfaces of the component. Thereafter the expandable material is activated to expand, wet, and adhere to one or more surfaces of the carrier member and one or more surfaces of the component of the automotive vehicle. Upon
10 curing, the expandable material preferably forms a rigid structural foam securing the reinforcement member within the cavity of the component of the vehicle thereby reinforcing the component.

 According to one exemplary embodiment shown in Fig. 3, there is illustrated the exemplary reinforcement member 40 that includes the carrier member 10 with the
15 expandable material 30 disposed thereon. As shown, the reinforcement member 40 is suitable for placement adjacent to a structural member 50 (e.g., a pillar structure) or within a cavity 60 of the structural member 50, which is preferably a component of an automotive vehicle. In the embodiment shown, the structural member 50 has a generally rectangular cavity 60 corresponding to the configuration of the carrier member
20 10, the reinforcement member 40 or both. However, it shall be understood that the structural member 50 may be formed in nearly any shape or configuration depending upon the intended use of the member 50 and depending upon other factors.

Alternative Members

25 In one alternative embodiment, it has been found that a cellular carrier member according to the present invention can be particularly useful for forming a baffle. Advantageously, such a cellular carrier member can form a lower weight baffle without significantly reducing sound absorption/attenuation characteristics or sealing characteristics of the baffle relative to a substantially identical baffle formed with a non-
30 cellular carrier. As will be recognized, such a carrier member may be formed using any of the above described techniques. Although such baffles may be employed by

themselves, it has been further found that these baffles may be employed in conjunction with a reinforcement member such as those discussed or shown. Advantageously such a baffle/reinforcement combination can quite effectively provide a structure of an automotive vehicle or other article with sound absorption/attenuation, sealing, structural reinforcement, a combination thereof or the like.

Referring to Fig. 4, there is illustrated a combined baffle/reinforcement 80 having a baffle 82 combined with (e.g., attached to) a structural reinforcement member 84. The baffle/reinforcement 80 illustrated in Fig. 4 is configured for insertion into a cavity 88 defined by internal walls 90 of a structure 92 of an article of manufacture. In the embodiment shown, the structure 92 is a D-pillar of an automotive vehicle, however, in alternative embodiments, the structure may be any of those discussed herein.

The reinforcement member 84 illustrated includes a carrier member 98 that extends along a central axis 100. As shown, the carrier member 98 is shaped as a hollow shell with an internal surface defining an internal cavity 104 and an external surface 106 that is shaped to substantially correspond to the walls 90 of the structure 92. Of course, it is contemplated that the carrier member may be shaped in a variety of configurations as discussed herein and may additionally include components such as ribs or the like.

The carrier member 98 of the reinforcement member 84 may be formed of any of the materials, particularly the polymeric materials for the carrier member, discussed herein. In one embodiment, the carrier member 98 is formed of one of the cellular polymeric materials (e.g., cellular nylon) discussed herein. In another embodiment, the carrier member 98 is formed of sheet molding compound (SMC).

The baffle 82 also includes a carrier member 108. As shown, the carrier member 108 is substantially planar and L-shaped. The carrier member 108 is illustrated as being skew or substantially perpendicular to the axis 100 of the reinforcement member 84. The carrier member 108 also includes an outer peripheral edge 110 extending substantially continuously about the carrier member 108 and the carrier member 108 is substantially continuous within the area defined by the peripheral edge 110, although not required. Preferably, the peripheral edge 110 is shaped to correspond to (e.g., be continuously adjacent) the walls 90 of the structure 92 upon

insertion of the baffle/reinforcement 80 into the cavity 88. It should be understood that, although the shape of the carrier member 108 has been specifically described, the carrier member 108 of the baffle 82 could also be shaped in a variety of configurations alternative to that shown and discussed.

5 The carrier member 108 of the baffle 82 may also be formed of any of the materials, particularly the polymeric materials for the carrier member, discussed herein. In one embodiment, the carrier member 108 is formed of one of the cellular polymeric materials (e.g., cellular nylon) discussed herein. Of course, the carrier member 108 may be formed of alternative non-cellular materials.

10 The baffle 82 may be attached to the reinforcement member 84 or they may be unattached, but employed adjacent to each other. As discussed, it is also possible to employ the baffle 82 and the reinforcement 84 separately. In the embodiment shown, the baffle 82 is attached to the reinforcement member 84 with one or more mechanical fasteners 116, but other fasteners such as adhesives, magnets or the like may be
15 employed and the fasteners may or may not be integrally formed with the reinforcement member 84 and/or the baffle 82.

Both the carrier member 108 of the baffle 82 and the carrier member 98 of the reinforcement member 84 respectively have masses 120, 122 of expandable material disposed thereon. The reinforcement member 84 has a plurality of masses 122 of
20 expandable material disposed upon various portions of the outer surface 106 of the member 84. The baffle 82, on the other hand, includes one substantially continuous mass 120 of expandable material. It is contemplated, however, that the single mass may be divided into or replaced by multiple masses. In the embodiment depicted, the mass 120 overlays the carrier member 108 of the baffle 82 and is substantially planar
25 and coextensive therewith. The mass 120 also extends substantially continuously adjacent the peripheral edge 110 of the carrier member 108.

The expandable material on the baffle 82 and the expandable material on the reinforcement 84 may be any of the expandable materials discussed herein. Moreover, the expandable material on the baffle 82 and the expandable material on the
30 reinforcement 84 may be the same, but are preferably different. In particular, the expandable material associated with the baffle 82 is preferably configured to

volumetrically expand to at least about 350%, more preferably at least about 600% and still more preferably at least about 1000% relative to its original unexpanded volume while the expandable material associated with the reinforcement member 84 is preferably configured to volumetrically expand between about 10% and about 800%,
5 more preferably between about 30% and about 400% and even more preferably between about 100% and about 300% relative to its original unexpanded volume.

The baffle 82 and the reinforcement member 84 of baffle/reinforcement 80 may be inserted within the cavity 88 of the structure 92 separately or as a unit. Upon insertion, the outer surface 106 of the carrier member 98 of the reinforcement member
10 84 and the peripheral edge 110 of the carrier member 108 of the baffle 82 are preferably continuously adjacent and substantially opposing the walls 90 defining the cavity 88. It should be understood that various supports or fasteners such as mechanical fasteners, adhesives, magnets, combinations thereof or the like, which may be integral with or attached to the baffle, the reinforcement member or both and may be
15 utilized to assist in locating the baffle or the reinforcement member alone or as a combination within the cavity at least until the expandable material is expanded and cured.

After insertion, the masses 120, 122 of expandable material are preferably activated to expand, contact and wet the walls 90 of the structure 92 and cure to adhere
20 the reinforcement member 84, the baffle 82 or both to the walls 90. Preferably, the mass 120 of expandable material of the baffle 82 substantially continuously spans a cross-section of the structure 92 for dividing the cavity 88 into at least two compartments that are substantially sealed against the passage of materials therebetween. Advantageously, the reinforcement member 84 provides structural
25 integrity to the structure 92 while the baffle provides baffling, sealing, noise attenuation/damping, combinations thereof or the like to the structure 92.

Unless stated otherwise, dimensions and geometries of the various structures depicted herein are not intended to be restrictive of the invention, and other dimensions or geometries are possible. Plural structural components can be provided by a single
30 integrated structure. Alternatively, a single integrated structure might be divided into separate plural components. In addition, while a feature of the present invention may

have been described in the context of only one of the illustrated embodiments, such feature may be combined with one or more other features of other embodiments, for any given application. It will also be appreciated from the above that the fabrication of the unique structures herein and the operation thereof also constitute methods in accordance with the present invention.

The preferred embodiment of the present invention has been disclosed. A person of ordinary skill in the art would realize however, that certain modifications would come within the teachings of this invention. Therefore, the following claims should be studied to determine the true scope and content of the invention.